

Date: Friday, 8/10/2007 10:33:02 AM  
User: Jean-Luc Menard

## Process Sheet

|                       |                                       |                  |                    |
|-----------------------|---------------------------------------|------------------|--------------------|
| Customer              | : CU-DAR001 Dart Helicopters Services | Drawing Name     | : WEARPAD          |
| Job Number            | : 33869                               |                  |                    |
| Estimate Number       | : 12801                               |                  |                    |
| P.O. Number           | : <i>N/A</i>                          | Part Number      | : D35377           |
| This Issue            | : 8/10/2007 S.O. No. : <i>N/A</i>     | Drawing Number   | : D3537 REV C      |
| Prsht Rev.            | : NC                                  | Project Number   | : <i>N/A</i>       |
| First Issue           | : <i>N/A</i> Type : SMALL /MED FAB    | Drawing Revision | : C                |
| Previous Run          | : 31911                               | Material         | : <i>N/A</i>       |
| Written By            | : <i>[Signature]</i>                  | Due Date         | : 8/17/2007        |
| Checked & Approved By | : <i>[Signature]</i>                  | Qty:             | <i>55</i> Um: Each |
| Comment               | : Est Rev:A New Issue 07-03-12 ec     |                  |                    |

## Additional Product

Job Number:



|         |                       |               |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

|     |           |                    |
|-----|-----------|--------------------|
| 1.0 | M304S16GA | 304/316 .063 Sheet |
|-----|-----------|--------------------|



Comment: Qty.: 0.1512 sf(s)/Unit Total : 7.5600 sf(s)  
M304S16GA Stainless steel sheet 0.063" thick  
Batch: *M105130*

SAD 07/08/13

|     |           |                |
|-----|-----------|----------------|
| 2.0 | WATER JET | FLOW WATER JET |
|-----|-----------|----------------|



Comment: FLOW WATER JET  
1-Cut as per Dwg D3537  
Dwg Rev: *C*  
Prog Rev: *C*

2-Deburr if necessary

SAD 07/08/14

SAD 07/08/13

55

|     |     |  |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SAD 07/08/13

54

|     |     |              |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

En 07/08/13

*counter*  
*(X55)*

|     |          |          |
|-----|----------|----------|
| 5.0 | BRAKE NC | NC BRAKE |
|-----|----------|----------|



Comment: NC BRAKE

Deburr if necessary *SAD 07/08/14* *K5*  
Form on Brake as per Dwg D3537 using Jigs DT8261 and DT8326.

*SAD 07/08/15* *(55)*



## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEARPAD

Job Number: 33869

Part Number: D35377

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC5

INSPECT WORK TO CURRENT STEP



counted

Comment: INSPECT WORK TO CURRENT STEP

Ensure joggle as per dwg D3429

EN 07/08/05 (55)

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Qty Description Batch  
A/R 2059B Hardcoat  
Weld hardcoat as per Dwg D3437

Batch

M105315

SL 07/09/05

(55)

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

107/09/06 (55)

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

107/09/06 (55)

10.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3

M104846

Fd 07/09/07 (55)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

25 07-09-08

(55)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock  
Location: FE-17

Fd 07/09/11 (55)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

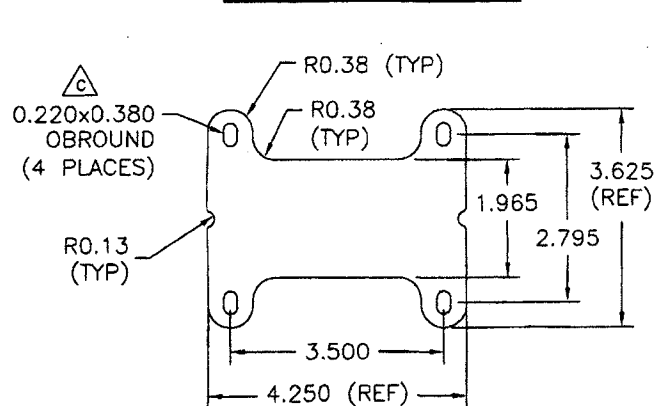
07/09/13

Job Completion

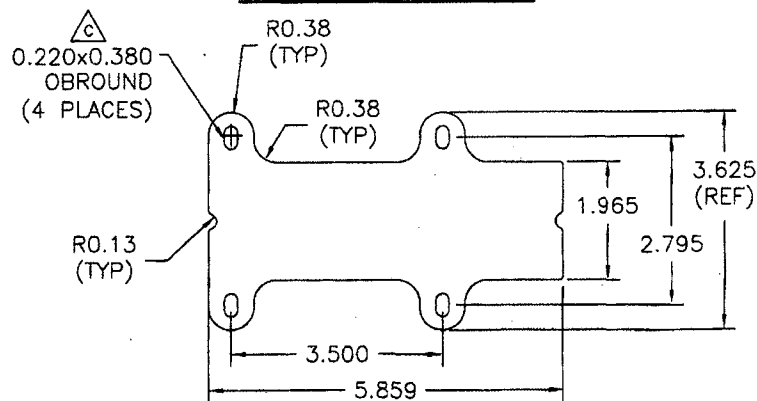


u 07-09-13

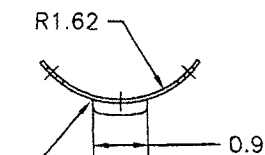
### D3537-1F FLAT PATTERN



### D3537-3F FLAT PATTERN

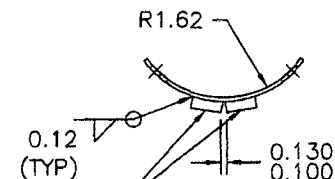


### SECTION A-A



APPLY 2 LAYERS OF 2059B HARDCOAT WELDS TO WITHIN 0.25 OF WEARPAD ENDS 0.188 TO 0.250 THICK

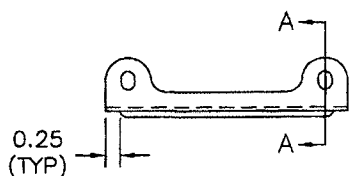
### SECTION B-B



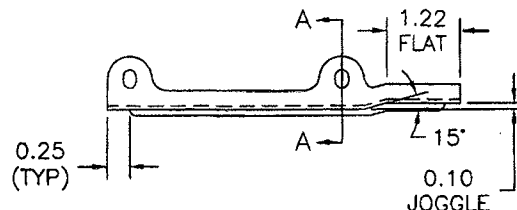
D2941-300 REMOVE POWDER COAT FROM THESE SURFACES

**RELEASED**  
07-05-08 AH  
PER ECU 952

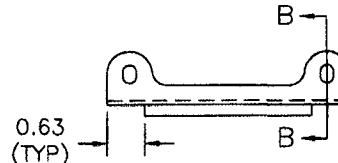
### D3537-1 LONGITUDINAL BEND (MADE FROM D3537-1F)



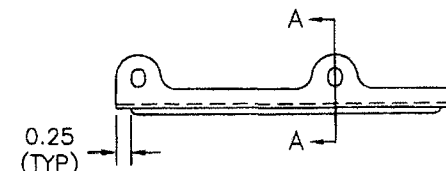
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)



### D3537-1/-3/-5/-7 WEARPAD NOTES

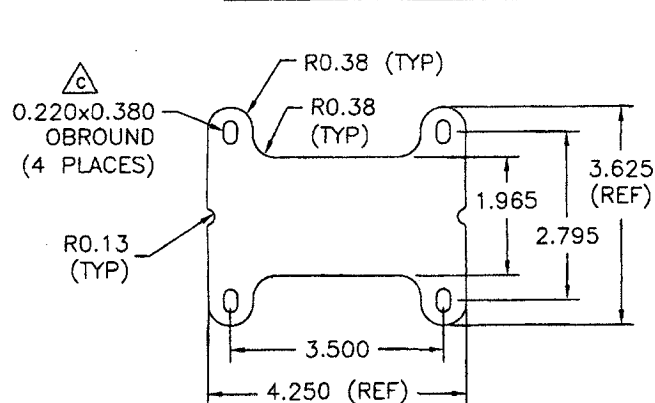
- 1) MATERIAL: AISI 304/316 SS SHEET PER AMS 5513 OR AMS 5524, 16 GAUGE (0.063 THICK)  
(REF DART SPEC. M304S16GA)
- 2) BREAK ALL SHARP CORNERS 0.063 MAX
- 3) WELD PER QSI 004
- 4) FINISH: POWDER COAT GREY SANDEX (4.3.5.6) PER QSI 005 4.3
- 5) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 6) ALL DIMENSIONS ARE IN INCHES

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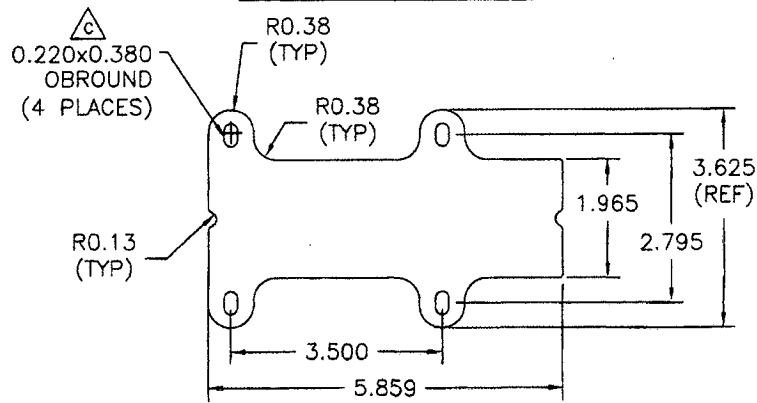
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|                          |                  |                                  |
|--------------------------|------------------|----------------------------------|
| C                        | 07.04.13         | WIDEN TAB TO 0.380, WELD PATTERN |
| B                        | 07.03.20         | ADD AMS 5513 AND AMS 5524        |
| A                        | 06.11.06         | NEW ISSUE                        |
| DESIGN                   | C.B.             | DRAWN BY PH                      |
| CHECKED                  | #                | APPROVED #                       |
| DATE                     | 07.04.13         | TITLE WEARPAD                    |
| DART AEROSPACE USA, INC. | PORT HADLOCK, MA | DRAWING NO. D3537                |
| REV. C                   | SHEET 1 OF 1     | SCALE 1:2                        |

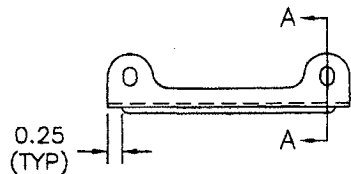
### D3537-1F FLAT PATTERN



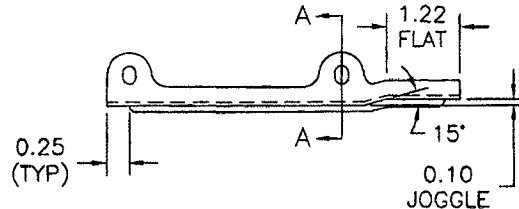
### D3537-3F FLAT PATTERN



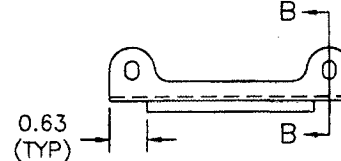
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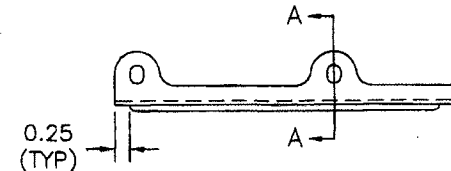
### D3537-3 LONGITUDINAL BEND (MADE FROM D3537-3F)



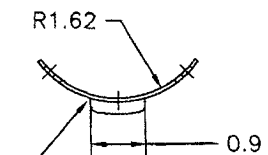
### D3537-5 LONGITUDINAL BEND (MADE FROM D3537-1F)



### D3537-7 LONGITUDINAL BEND (MADE FROM D3537-3F)

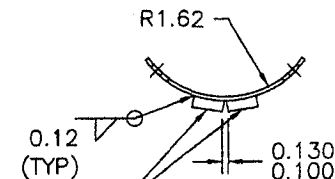


### SECTION A-A



APPLY 2 LAYERS OF  
2059B HARDCOAT WELDS  
TO WITHIN 0.25 OF  
WEARPAD ENDS  
0.188 TO 0.250 THICK

### SECTION B-B



D2941-300  
REMOVE POWDER  
COAT FROM THESE  
SURFACES

**RELEASED**  
07-05-08 PM  
DRT ELN  
952

### D3537-1/-3/-5/-7 WEARPAD NOTES

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|             |          | SHEET 1 OF 1                     |
|             |          | SCALE 1:2                        |

**DART** DART AEROSPACE USA, INC.  
PORT HADLOCK, MA

